

TIG filler metal Inox 308L in rod form for welding molybdenum-free austenitic stainless steels (304, 304L, 321, 347). Recommended as a first pass in all cases where even penetration and good compactness are required.

Classification

AWS A5.9 : ER 308L
EN ISO 14343-A : W19 9 L

Applications

- Piping, thin-walled structures up to and including equal to or less than 3 mm and for penetration passes,
- Reserved for assemblies not exceeding 350°C operating temperature.

Product benefits

- Suitable for food, organic acid... (308L).
- Corrosion-resistant.

Chemical properties

C max %	Mn %	Si %	Cr %	Ni %	S max	P max	Fe
0.025	1.80	0.45	20.20	10.00	0.02	0.02	Base

Mechanical properties

Rp 0,2	Rm	A 5 d	KV -196°C
400 Mpa	600 Mpa	38%	48 J

Recommandations

Ø electrode (mm)	1,6	2	2,4
thickness (mm)	1,5 ▶ 2,0	2,0 ▶ 2,5	2,5 ▶ 3,0
welding current (A)	60 ▶ 95	90 ▶ 110	120 ▶ 150

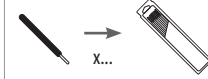
Gas protection to standard EN ISO 14175

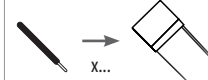
100% Argon (I1) : 6-12 l/min

Reverse: Argon / Nitrogen: 3-6 l/min



Packaging

Réf.	Ø (mm)	length (mm)	
087248	Ø 1.6	330	60
087255	Ø 2.0	330	40

Réf.	Ø (mm)	length (mm)	
087118	Ø 1.2	1000	560
087156	Ø 1.6	1000	319
087163	Ø 2.0	1000	204